

Date:
User:Monday, 12/01/2009 2:30:34 PM
Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Job Number : 44565 -1

Estimate Number : 11093

P.O. Number :

This Issue : 12/01/2009 S.O. No. :

Prsht Rev. : NC

First Issue : 11

Previous Run : 44564

Type : LARGE FAB ASSY

Written By :

Checked & Approved By : JUD 09 01 12

Comment : Est. C 02.01.23 Revised NG

Est Rev:D 08-04-16 now water jet DD verified by:EC

Drawing Name : BACK PANEL

Part Number : D30231 64

Drawing Number : D3023 REV A

Project Number : N/A

Drawing Revision : A

Material :

Due Date : 10/02/2009

Qty: 1 Um: Each *split*

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M2024T3S032

2024-T3 .032 sheet



Comment: Qty.: 3.0216 sf(s)/Unit Total : 3.0216 sf(s)

2024-T3 .032 sheet

Material: 2024-T3 sheet (QQ-A-250/4) 0.032"

Batch: 110778 1B9-2-10

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3023

Dwg Rev: AProg Rev: A

****grain direction along 28.100" ****

2-Deburr if necessary

1B9-2-10

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

509/02/10 (X2)

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Bend as per Dwg D3023

509/02/25

Date: Monday, 12/01/2009 2:30:34 PM
User: Julie Dawson

Process Sheet

Drawing Name: BACK PANEL

Customer: CU-DAR001 Dart Helicopters Services

Job Number: 44565

Part Number: D30231

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-form edge of back pan as per dwg D3023 using D3017-041 back frame

EL 9-6-22

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509/06/23 (X)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

UMP 09/06/24 (X1)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M109091

START TIME:

11:30am

OVEN TEMPERATURE:

320°F

FINISH TIME:

12:00pm

JA

09-06-24 (X)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

JK 09-06-24 (X)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

9/6/24

(10)

31

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/24 (X)

Job Completion



U 09-06-24

DART AEROSPACE LTD		Work Order: <i>W4565</i>	
Description: Back Panel		Part Number: D3023-1	
Inspection Dwg: D3023 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

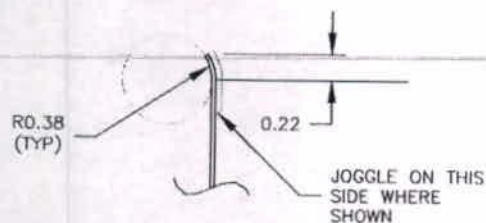
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	.129	X			
Ø0.191	+0.005/-0.001	.196	✓			
1.660	+/-0.010	1.658	✓			
0.375	+/-0.010	.374	X			
1.340	+/-0.010	1.336	✓			
2.375	+/-0.010	2.375	X			
0.375	+/-0.010	.373	✓			
25.28	+/-0.030	25.28	X			
27.03	+/-0.030	27.03	X			
28.10	+/-0.030	28.10	X			
1.30	+/-0.030	1.292	✓			
2.375	+/-0.010	2.374	X			
8.711	+/-0.010	8.712	✓			
5.597	+/-0.010	5.595	✓			
8.57	+/-0.030	8.57	✓			
1.970	+/-0.010	1.973	✓			
7.42	+/-0.030	7.420	✓			
10.92	+/-0.030	10.920	✓			
14.75	+/-0.030	14.75	✓			

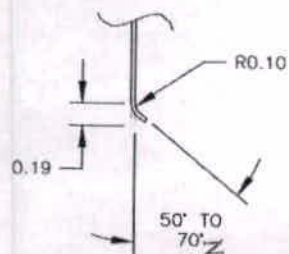
Measured by: <i>WB</i>	Audited by: <i>S</i>	Prototype Approval:	N/A
Date: <i>9-2-16</i>	Date: <i>09/02/10</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.27	New Issue	KJ/EC <i>[Signature]</i>	<i>[Signature]</i>

SECTION A-A
SCALE 1:1
(TYPICAL, EXCEPT WHERE SHOWN)

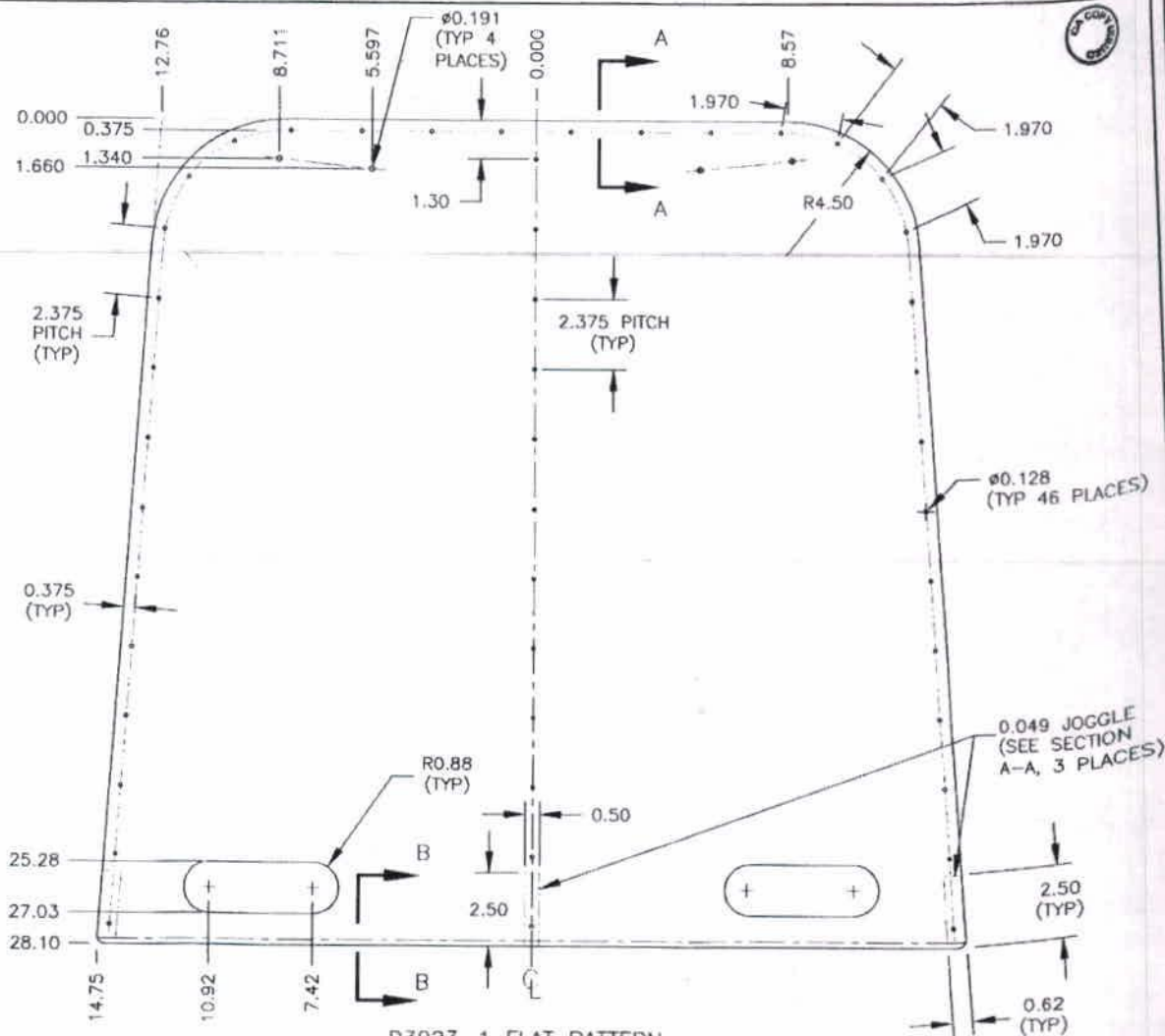


SECTION B-B
SCALE 1:1
(BOTTOM EDGE ONLY)



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WITHOUT NOTICE

D3023-1 BEND DETAIL



D3023-1 FLAT PATTERN

D3023-1 BACK PANEL:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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A	01.05.18	NEW ISSUE
DESIGN	CL	DRAWN BY CL
CHECKED	CL	APPROVED
DATE	01.05.18	TITLE
		BACK PANEL

DART DART AEROSPACE LTD.
HARRISBURG, OHIO, CANADA

REV. 1
SHEET 1 OF 1
SCALE 1: